Work Order ID 83547 *83547*

April-19-12 11:31:35 AM

Item ID: D3505-1 **Accept** *N900040100* **Setup Start** *NS1* **Stop** *NS2*

Revision ID:

Item Name: Web

Start Date: 19/04/2012 **Start Qty:** 4.00 *4* **Cust Item ID:**

Required Date: 03/05/2012 **Req'd Qty:** 4.00 *4* **Customer:**

Reference:

Approvals: **Process Plan:** MLJ **Date:** 12/04/19 **Tooling:** ______ **Date:** ______ **Run Start** *NR1*

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______ **Stop** *NR2*

Draw Nbr	Revision Nbr
D3505	Rev A

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100 *100* Skidtubes Skidtubes	Skidtubes	0.00							
	Memo 1-Cut to Lengh as per Dwg D35052-Drill Pillot Holes using DT8869 Drill Jig3-Open pillots to 1.000" as per Dwg D35054-Deburr	0.00							DC 12/04/19
110 *110* QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00							DP 12-4-19 (4)
	Memo	0.00							
120 *120* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1	0.00							(4) H 12-4-20
	Memo	0.00							

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W/O:	WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B					
DATE	**STEP**	**Description of NC** Section A	**Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector

NOTE: Date & initial all entries

Work Order ID 83547

April-19-12 11:31:35 AM

83547

Item ID:	D3505-1	**Accept**	*N900040100*
Revision ID:		**Setup Start**	*NS1*
Item Name:	Web	**Stop**	*NS2*
Start Date:	19/04/2012	**Start Qty:** 4.00	*4*
Required Date:	03/05/2012	**Req'd Qty:** 4.00	*4*
Reference:		**Cust Item ID:**	
		Customer:	

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Run Start *NR1* **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	~~QC3~~- Inspect Part Finish QC7 Memo	0.00 0.00				DP 12-4-23 (4)			
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: LG Memo	0.00 0.00				DC 12/04/23			
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				12/4/23			

12-04-23

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W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Picklist Print

April-19-12 11:31:39 AM

Work Order ID: 83547 *83547*

Parent Item: D3505-1 *D3505-1*

Parent Item Name: Web

Start Date: 19/04/2012 **Required Date:** 03/05/2012

Start Qty: 4.00 **Required Qty:** 4.00

Comments: IPP Rev:A New Issue 06-05-30 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2963-125 *D2963-125* 105 I Beam Extrusion		Manufactured	No			120	Each	78.0000	1	4			

** DC 12/04/19

Location	Loc Qty	Loc Code	
HALL	78		
~~27775~~	14		
28673	64		4

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

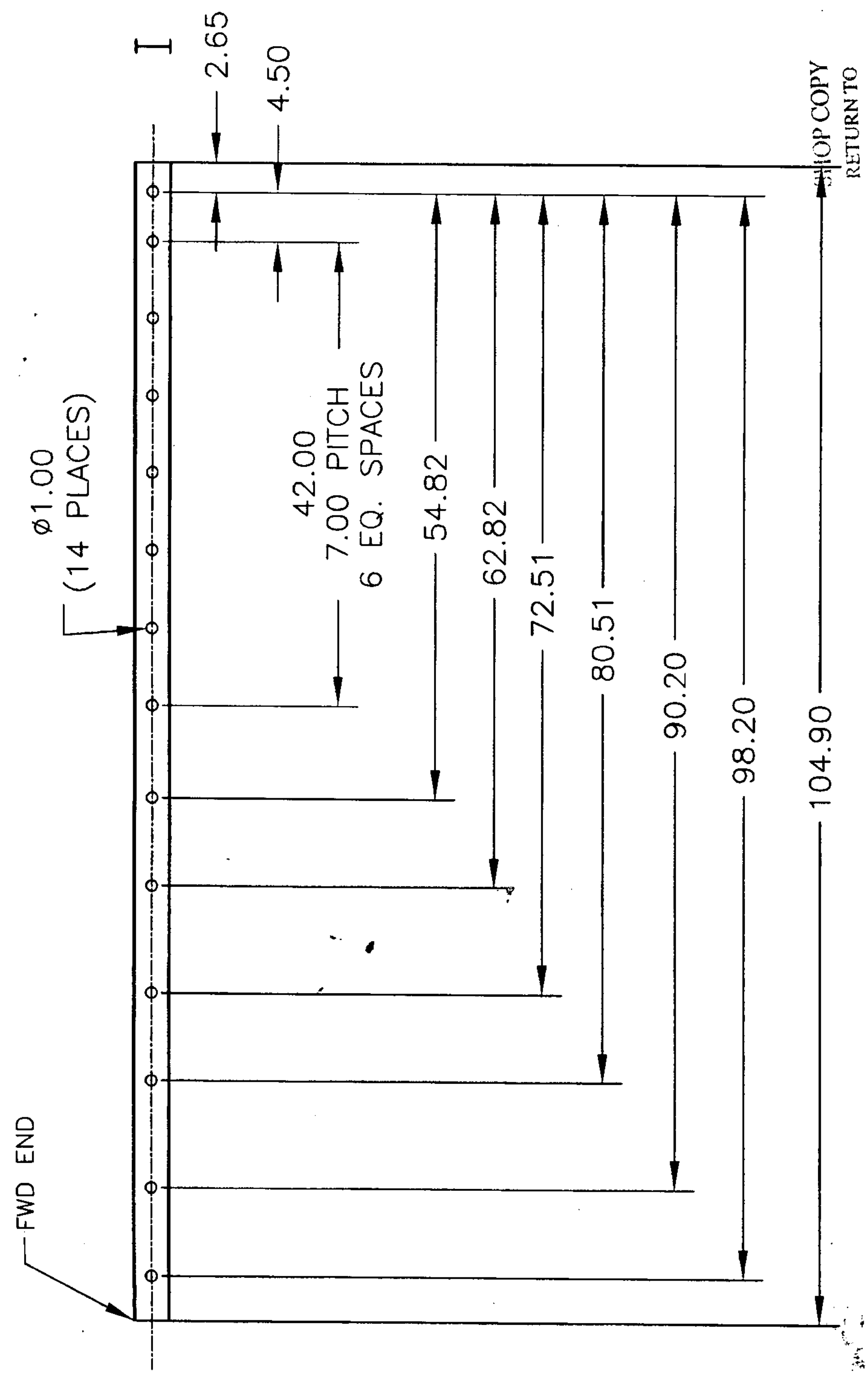
Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
PH	RA		
CHECKED	APPROVED	DRAWING NO. D3505	REV. A SHEET 1 OF 1
DATE 06.04.21		TITLE WEB	SCALE 1:15
A	06.04.21	NEW ISSUE	



SHOP COPY
RETURN TO ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT WITHOUT NOTICE
WORK ORDER NO. 8353 MC5 12/04/19

RELEASED 06.10.02 PH
per ECN #851

D3505-1 WEB

D3505-1 WEB

1) MATERIAL: MAKE FROM D2963-125 EXTRUSION
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) DEBURR SHARP EDGES 0.010 TO 0.020

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** ________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ________________ **Disposition:** ________________ **QA: N/C Closed:** _________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries